

Work Order ID 84944

84944

Page 1

May-29-12 1:12:37 PM

Item ID: D2929

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 29/05/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/30 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2929	Rev B					<u>CL</u>			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2929 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-								
<u>6061-100</u>	Deburr if necessary								<u>B12-6-7</u>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									<u>B12-6-7</u>
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									<u>54</u> <u>W 12-06-07</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

54 7/6/12-6-8

140 QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

54x 12/6/12

150 Identify as per dwg & Stock Location: 8T-2 (0.00

150

Packaging

Memo

0.00

Packaging

54x SP 12-6-8

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ME 12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 84944

84944

Parent Item: D2929

D2929

Parent Item Name: Spacer

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP A04.08.05New issueKJ/JLM
 IPP B 07.08.07 ECN930 EC verified by:JLM
 IPP Rev:C 08.11.13 Now on Waterjet JLN Verified By:EC
 IPP Rev: D 08.11.24 QC2 moved to step 3 , QC5 deleted from step7 KJ
 Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased	No			100	sf	69.7000	0.0425	1.789474	2		
M6061T6S 100									**				
6061-T6 .100 Sheet													

B12-6-7

Location

Loc Qty

Loc Code

MAT021

69.7

102201

1

118072

5.7

118523

63

118523

54

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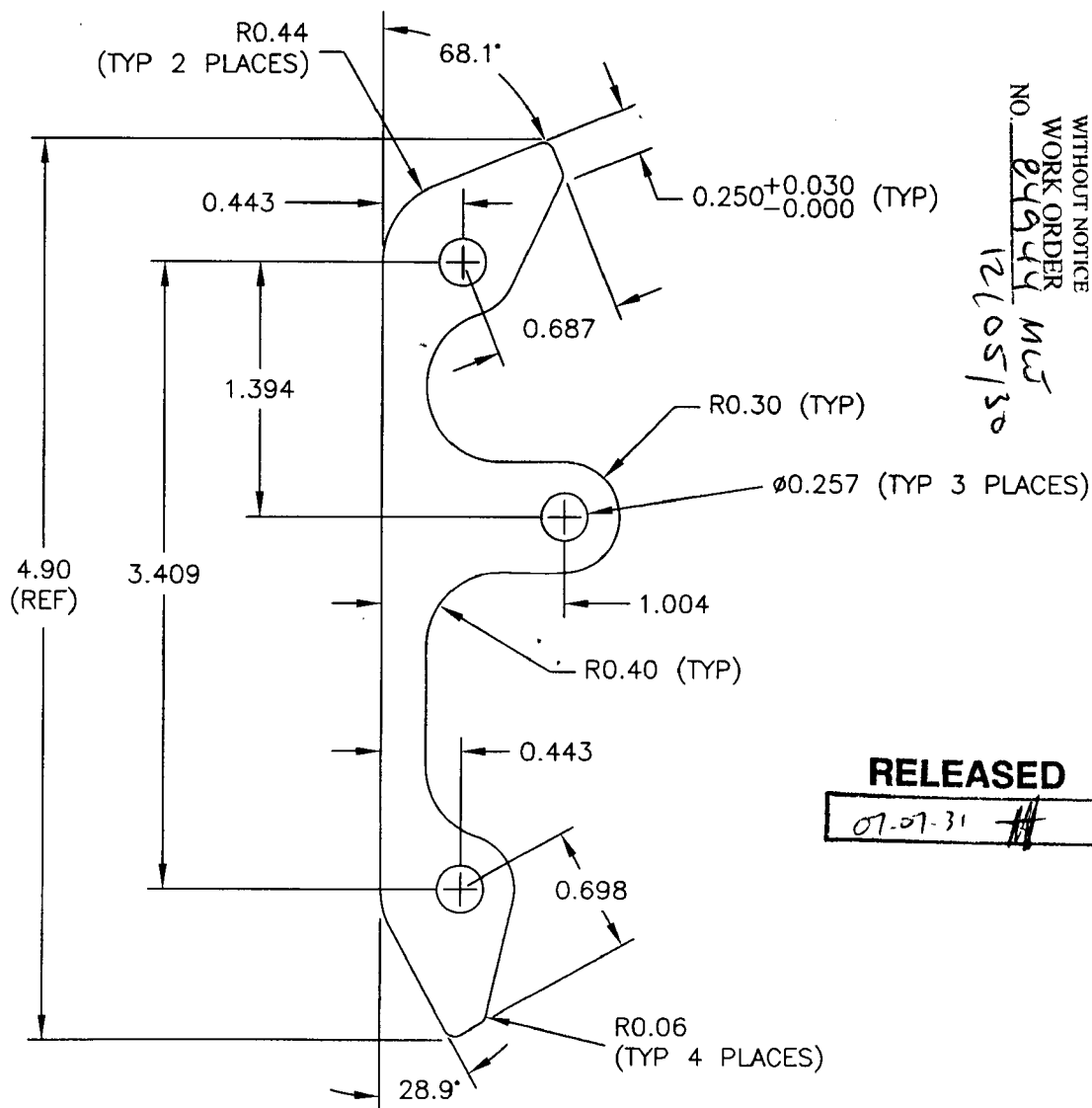
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DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D2929	REV. B SHEET 1 OF 1
DATE 07.06.26		TITLE SPACER	SCALE 1:1
A	99.10.27	NEW ISSUE	
B	07.06.26	ADD 6061-T6; UPDATE NOTES	



RELEASED

07-07-31 *HA*

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.100 THICK, PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.100) OR ALUMINUM 5052-H32/H34 SHEET, 0.100 THICK, PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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